

Date: Thursday, 4/12/2007 8:44:53 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 31716		
Estimate Number	: 10530		
P.O. Number	: <i>N/A</i>	Part Number	: D2571
This Issue	: 4/12/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2571 REV E
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31647	Drawing Revision	: E
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/30/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	12 Um: Each
Comment	: Est: 1'02:40.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2571  
 Ensure that grain is along 7.75" length  
 Batch No: 25254

*MS 07/04/25 12*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 31716 Double check by: J.L

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

*MS 07/04/25*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

*MS 07/05/03*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MS 07/05/03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: RD Date: 07/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:44:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31716

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 07/05/03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Feb

02/05/03

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103706

J.L. 07-05-07 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/05/08 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/05/08 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/08

Job Completion



C207105108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	31716
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.748	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.497	0.497	0.497	0.497		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.501	0.505	0.505		
J	1.174	1.184		1.174	1.178	1.176	1.176		
K	0.558	0.578		0.565	0.563	0.564	0.565		
L	1.174	1.184		1.174	1.178	1.176	1.176		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.498	2.500		
O	3.869	3.879		3.872	3.873	3.872	3.872		
P	0.115	0.135		0.128	0.128	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.252	0.252		
S	0.115	0.135		0.129	0.130	0.131	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	0.239	0.239	0.239		
W	0.115	0.135		0.122	0.120	0.121	0.120		
X	0.308	0.313		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.367	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.501	0.500		
AB	0.615	0.635		0.630	0.629	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.250	0.250	0.250		
AE	1.375	1.395		1.386	1.387	1.384	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.253	0.253	0.255	0.255		
AI	2.000	2.020		2.002	2.002	2.000	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	Er
Date:	02/04/24

Audited by:	JL
Date:	07/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>31716</b>
<b>Description: Saddle, Fwd Outboard</b>	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg: D2571 Rev. E</b>		<b>Page 1 of 1</b>

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B	1.745	1.755		1.750	1.749	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.501	3.499		
D	1.745	1.755		1.750	1.749	1.748	1.748		
E	7.990	8.010		8.000	8.003	8.003	8.004		
F	0.490	0.510		0.500	0.495	0.497	0.496		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.501	0.501		
J	1.174	1.184		1.179	1.178	1.176	1.178		
K	0.558	0.578		0.568	0.563	0.566	0.565		
L	1.174	1.184		1.179	1.178	1.176	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.498	2.497	2.498		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		0.125	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.252	0.252	0.252		
S	0.115	0.135		0.125	0.129	0.128	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.246	0.238	0.237	0.238		
W	0.115	0.135		0.125	0.119	0.119	0.121		
X	0.308	0.313		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.360	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.627	0.626		
AC	0.053	0.073		0.068	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.250	0.250		
AE	1.375	1.395		1.387	1.386	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.252	0.251	0.252		
AI	2.000	2.020		2.002	2.001	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	TEO
Date:	07/05/02

Audited by:	J.L
Date:	07/05/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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E	7.990	8.010		8.003	8.004	8.003	8.004		
F	0.490	0.510		0.495	0.499	0.496	0.498		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.379	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.503	0.503	0.502		
J	1.174	1.184		1.176	1.175	1.175	1.176		
K	0.558	0.578		0.565	0.566	0.567	0.564		
L	1.174	1.184		1.176	1.175	1.175	1.176		
M	1.490	1.500		1.493	1.494	1.494	1.496		
N	2.495	2.505		2.498	2.498	2.499	2.497		
O	3.869	3.879		3.870	3.871	3.873	3.871		
P	0.115	0.135		0.127	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.251	0.252		
S	0.115	0.135		0.128	0.131	0.130	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
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V	0.230	0.250		0.238	0.238	0.238	0.236		
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Y	0.760	0.765		0.765	0.765	0.765	0.765		
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AI	2.000	2.020		2.002	2.000	2.002	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									






Measured by:	En
Date:	07/05/02

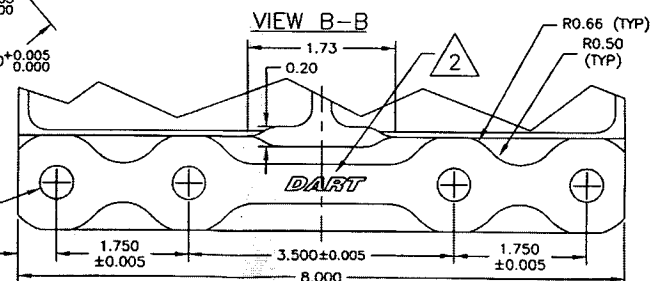
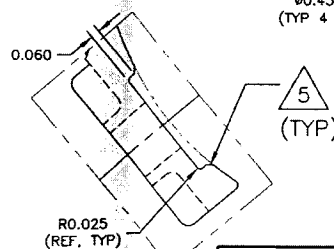
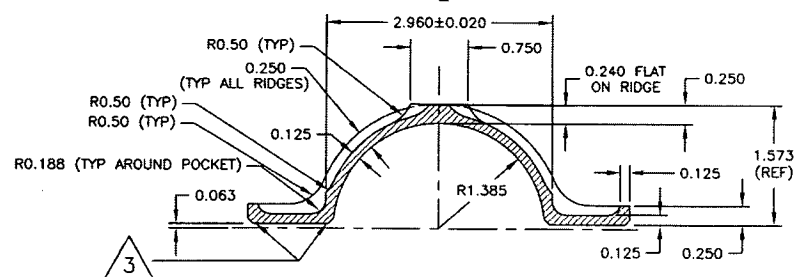
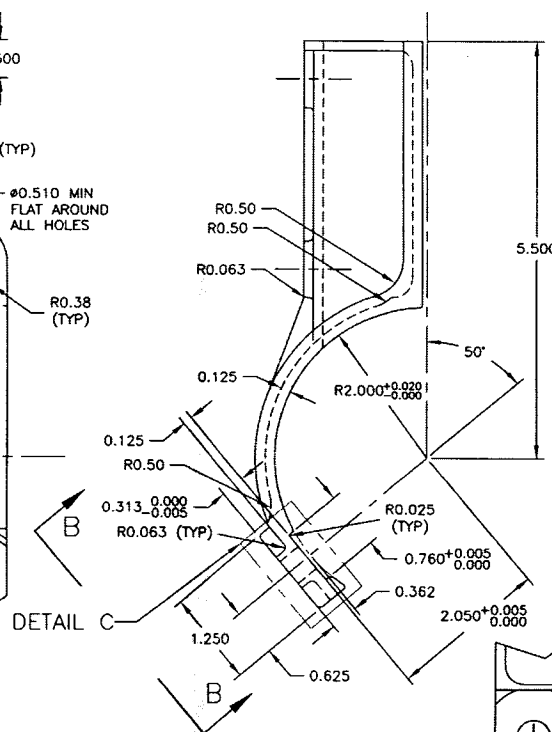
Audited by:	J.L
Date:	07/05/03


Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125       |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063" x 45° ALL AROUND                                  |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN OS		DRAWN BY PH
CHECKED #		APPROVED #
DATE 05.07.13		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA DRAWING NO. D2571 TITLE OUTER FWD SADDLE
		REV. SHEET 1 OF SCAL

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DETAIL C  
SCALE 4:3

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WORK ORDER  
NO. 31716